

Work Order ID 102921 -1

June-12-13 9:16:47 AM

Spl. 7-1

102921

Page 1

Item ID: D4095-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 6/17/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/17/13 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ

Date: 13-06-13

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-1)

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

10

0

Jm 13-06-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10

0

Jm 13-06-23

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

10

130624

DAS
09
28

Work Order ID 102921

102921

June-12-13 9:16:47 AM

Item ID:	D4095-041	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Wearplate Assembly					
Start Date:	6/17/13	Start Qty:	10.00	Cust Item ID:		
Required Date:	6/17/13	Req'd Qty:	10.00	Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						NR1
						NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00				10			8/13/07/09
130									
Brake NC	Memo	0.00							
Brake NC	1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157								
140	QC5- Inspect part completeness to step on W/O	0.00				10			
140									
QC	Memo	0.00							
Quality Control	Ensure joggle as per dwg D4095								
150	Weld per dwg A/R Hardcoat S.S. Batch: <u>M126003</u>	0.00							
150									
Large Fab	Memo	0.00							
Large Fab									

Handwritten mark

137.9

Split @ 6

QMA/EL 13-8-17

Work Order ID 102921

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102921

Page 3

Item ID: D4095-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearplate Assembly

Stop *NS2*

Start Date: 6/17/13

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/17/13

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

13 9-17

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

13 9-17

180

0.00

180

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH: 126136

6

13-07-18

Work Order ID 102921

102921

Page 4

June-12-13 9:16:47 AM

Item ID: D4095-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 6/17/13 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 6/17/13 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									

200	Identify as per dwg & Stock Location: <i>LP 002</i>	0.00							
200									
Packaging	Memo	0.00							
Packaging									

210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

6 *13-09-18* *13/9/18* *MJ* *13-09-18* *mf* *13-09-18*

Picklist Print

June-12-13 9:16:47 AM

Page 1

Work Order ID: 102921
Parent Item: D4095-041
Parent Item Name: Wearplate Assembly

Start Date: 6/17/13
Start Qty: 10.00

Required Date: 6/17/13
Required Qty: 10.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	280.7102	2.275	23.947368			

24

Jm13-06-23

Location

Loc Qty

Loc Code

MAT020

280.7101686

122245

0.1713688

123136

140.8

124428

23.61

124572

7.0181688

125599

109.110631

125577

DART AEROSPACE LTD		Work Order:	102921
Description: Wearplate		Part Number:	D4095-1
Inspection Dwg: D4095 Rev: B		Page 1 of 1	

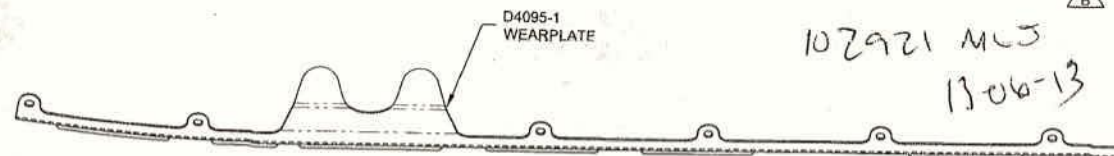
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.190"	-		V	Spec.
0.300	+/-0.010	0.301"	-		V	
0.300	+/-0.010	0.302"	-		V	
2.432	+/-0.010	2.436"	-		V	
3.227	+/-0.010	3.233"	-		V	
4.06	+/-0.030	4.065"	-		V	
4.98	+/-0.030	4.991"	-		V	
8.43	+/-0.030	8.43"	-		V	
9.22	+/-0.030	9.22"	-		V	P. 2.2.2.2.2
3.500	+/-0.010	3.500"	-		V	
24.750	+/-0.010	24.750"	-		T	
11.50	+/-0.030	11.505"	-		V	
11.472	+/-0.010	11.472"	-		V	
6.000	+/-0.010	6.002"	-		V	
12.104	+/-0.010	12.104"	-		T	
18.000	+/-0.010	18.000"	-		T	
30.000	+/-0.010	30.000"	-		T	
9.00	+/-0.030	9.005"	-		V	
36.000	+/-0.010	36.000"	-		T	
38.87	+/-0.030	38.87"	-		T	
2.50	+/-0.030	2.50"	-		V	
0.063	+/-0.010	0.068"	-		V	

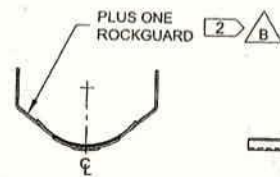
Measured by: Jim	Audited by: B0624 D4095	Preliminary Approval:
Date: 13-06-23	Date: 09	Date:

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-041	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

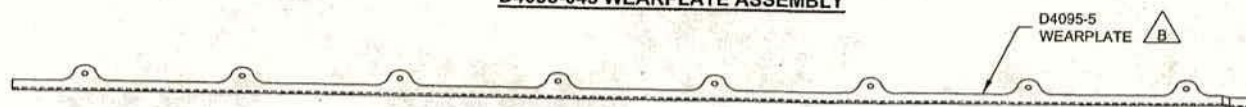
ITEM	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY

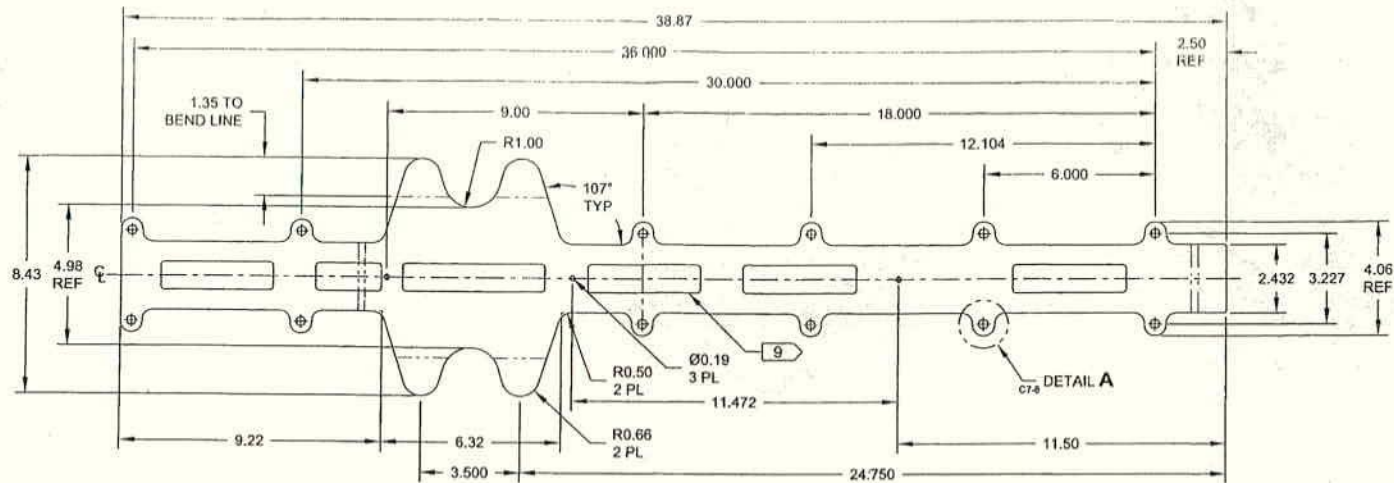
D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

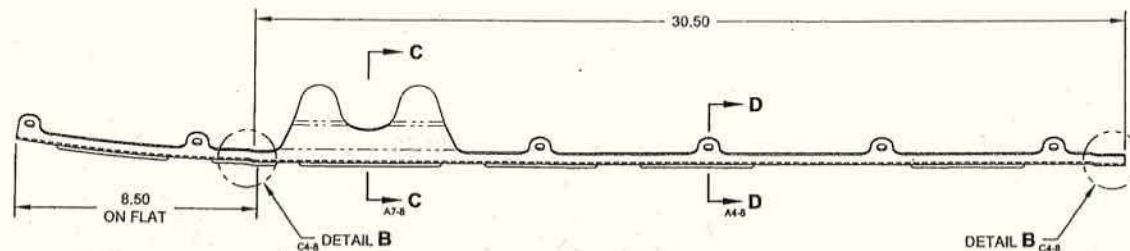
B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4095-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

DART AEROSPACE USA, INC
KENT, WA
DRAWING NO. D4095
TITLE WEARPLATE
REV. B
SHEET 1 OF B
SCALE
NTS
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102921



D4095-1F FLAT PATTERN



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

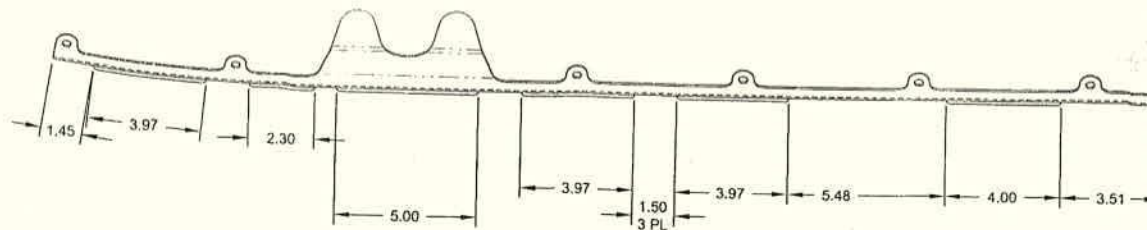
RELEASED
2011-10-31


D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/-11/-11F NOTES:

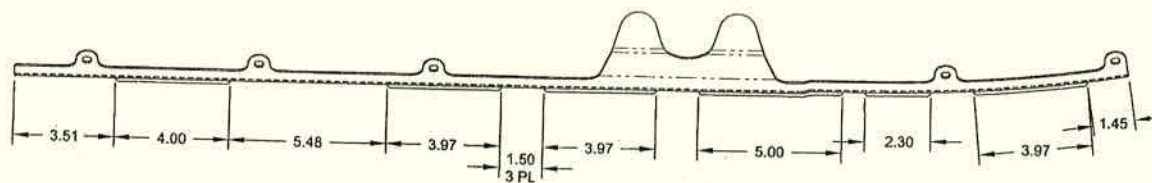
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C


DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO	REV. B
MFG. APPR.	AP	D4095	SHEET 3 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
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107221



D4095-1 WELDING DETAIL 

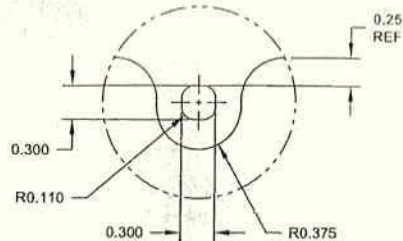


D4095-3 WELDING DETAIL 

RELEASED
2011-10-31
M

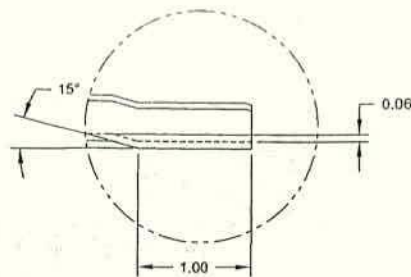
DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>10</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>10</i>	D4095	SHEET 5 OF 8
APPROVED	<i>10</i>	TITLE	SCALE
DE APPR.	<i>10</i>	WEARPLATE	NTS
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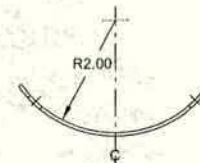
DETAIL A: TAB DETAIL

SCALE 4X
C3-3
C3-4
D3-6
D2-7



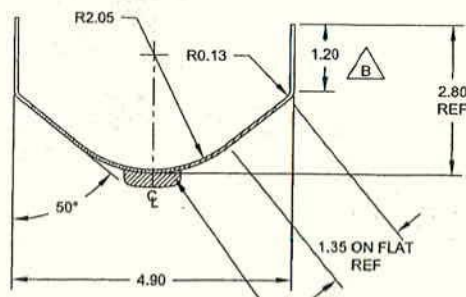
DETAIL B: JOGGLE DETAIL

SCALE 4X
B2-3
B6-3
B3-4
B2-6



SECTION E-E

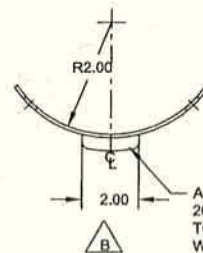
SCALE 2X
B5-6
B2-7



SECTION C-C

SCALE 2X
B5-3
B4-4

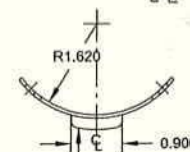
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION D-D

SCALE 2X
B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X
B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-31
NP

DESIGN		DART AEROSPACE USA, INC	
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MFG. APPR.	AP	D4095	SHEET 8 OF 8
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DE APPR.	AP	WEARPLATE	NTS
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